

result. There are occasional instances which require the location of a piece of work from a previously machined surface, in connection with a threaded portion by which it must be clamped. In a case of this kind, the "float" must be made so that it will

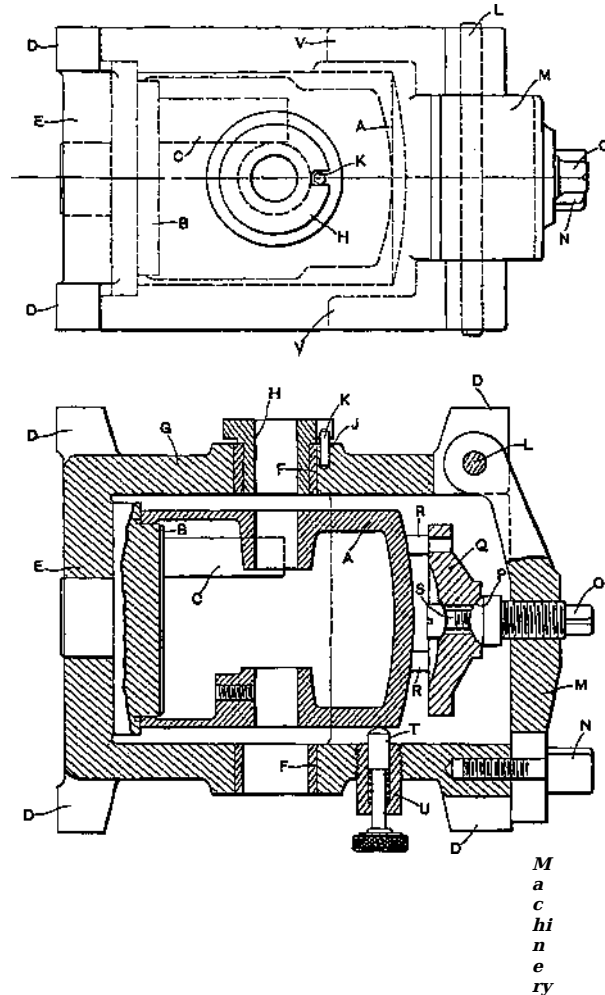


Fig. 1. Piston Drill Jig having Floating Clamps

take care of a possible lack of concentricity between the thread and the other finished surfaces and at the same time provide means of equalizing variations in the alignment of the thread. 3. Locking devices for floating members must be so arranged that the members can be positively locked or clamped without causing any change in their positions. A

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